

Date: Friday, 8/3/2007 10:01:26 AM
 User: Eric Charbonneau

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STA 129 BRACKET
Job Number	: 33601		
Estimate Number	: 11642		
P.O. Number	:	Part Number	: D29901
This Issue	: 8/3/2007 S.O. No. :	Drawing Number	: D2990 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 7/17/2007 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	:	Material	:
Written By	: <u>EC 07.08.03</u>	Due Date	: 8/10/2007 Qty: <u>10</u> Um: Each
Checked & Approved By	:		
Comment	: Est. A 01.31.01 New Issue EC est B 07.08.03 waterjet blank EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X12000	6061-T6 Bar .50" x 12.0"
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Comment: Qty.: 0.9913 f(s)/Unit Total : 6.9391 f(s)
 6061-T6 Bar .50" x 12.0"
 Material: 6061-T6 bar 12.00" x 0.50"
 Batch: M107508

SAV 07/08/03

10

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per template DT8547 ***(prog DT8547)***
 Dwg Rev: NA
 Prog Rev: NA
 2-Deburr if necessary

SAV 07/08/03

(10)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio FA107

SAV 07/08/13

(8)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAV 07/08/13

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAV 07.08.13

(8)

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Drawing Name: STA 129 BRACKET

Job Number: 33601

Part Number: D29901

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Tumble & Deburr

S.A. 07/08/13

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SG 07.08.15 (8)

8.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

M.P.S. 07-08-15 (8)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

C.P.S. 07/08/16 (8)

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

11 07.08.17

Job Completion



11 07-08-16

DART AEROSPACE LTD		Work Order:	33601
Description: STA 129 Bracket		Part Number:	D2990-1
Inspection Dwg: D2990 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.757	+0.005/-0.000	.759				
.438	+0.000/-0.001	.438				
Ø0.507	+0.000/-0.001	.5065				
5.690	+/-0.005	5.693				
R1.000	+/-0.010	1.000				
1.420	+/-0.001	1.421				
Ø0.191	+0.005/-0.000	.1915				
0.608	+0.000/-0.001	.609				
2.654	+0.000/-0.001	2.653				
0.125	+/-0.010	.126				
R0.062	+/-0.010	.063				
0.125	+/-0.010	.126				
0.250	+/-0.010	.251				
R0.125	+/-0.010	.126				
0.250	+0.000/-0.005	.249				
0.875	+0.000/-0.001	.874				

Measured by: <i>[Signature]</i>	Audited by: <i>SA</i>	Prototype Approval:	N/A
Date: 07/08/11	Date: 07.08.12	Date:	N/A

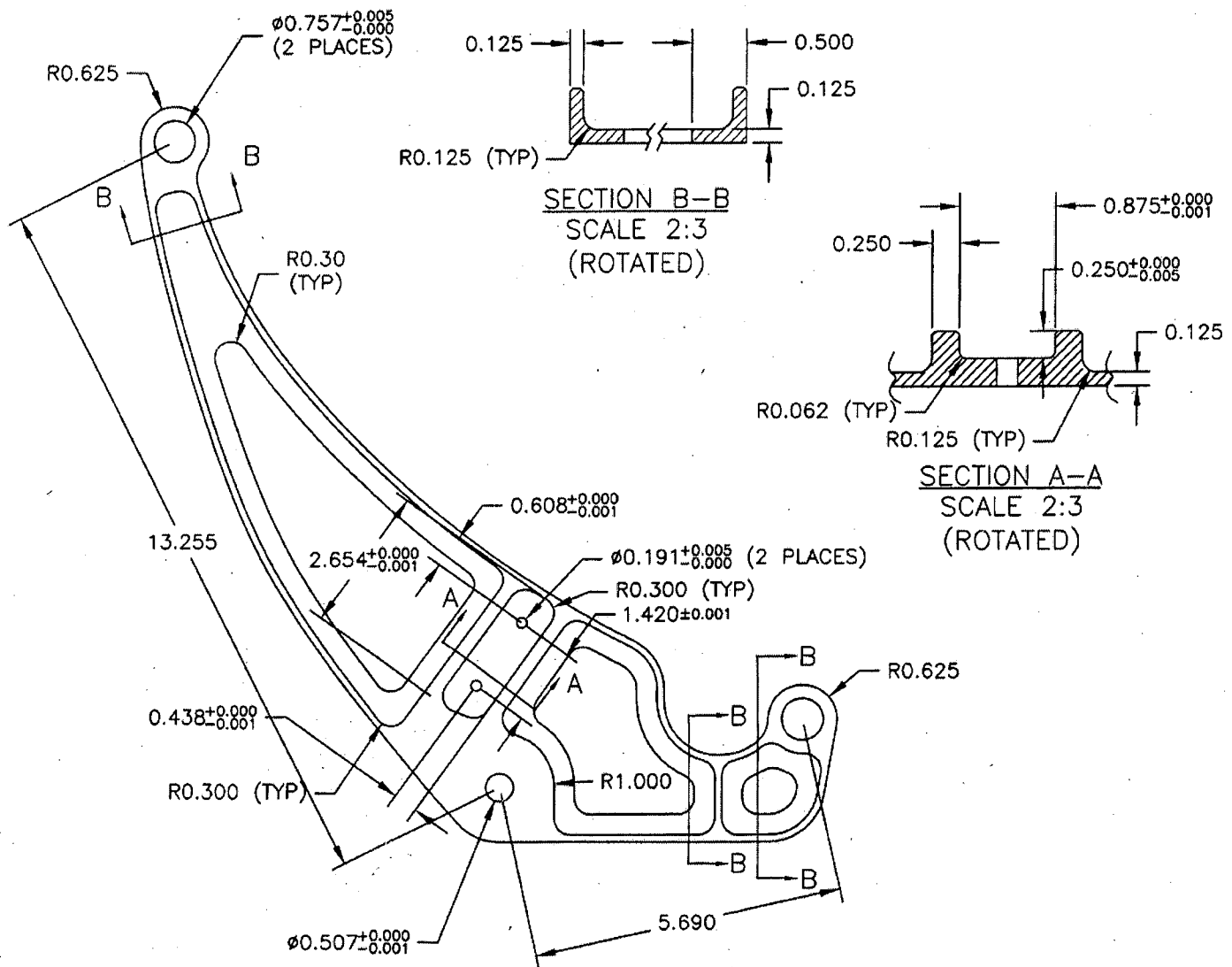
Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue	KJ/RF	
B	06.03.08	Dwg Rev. change	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D2990	REV. B
					SHEET 1 OF 2
DATE	05.01.20	TITLE	STA 129 BRACKET	SCALE	1:3
A	00.11.07	NEW ISSUE			
B	05.01.20	ADD CUTOUTS & -043/-044			

RELEASED

05-03-11 *[Signature]*



D2990-1 BRACKET (SHOWN). D2990-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2990.SLDPR1"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 33601

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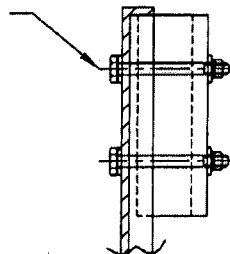


DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2990	REV. B SHEET 2 OF 2
DATE 05.01.21	TITLE STA 129 BRACKET		SCALE 1:3

RELEASED

05.03.11 #

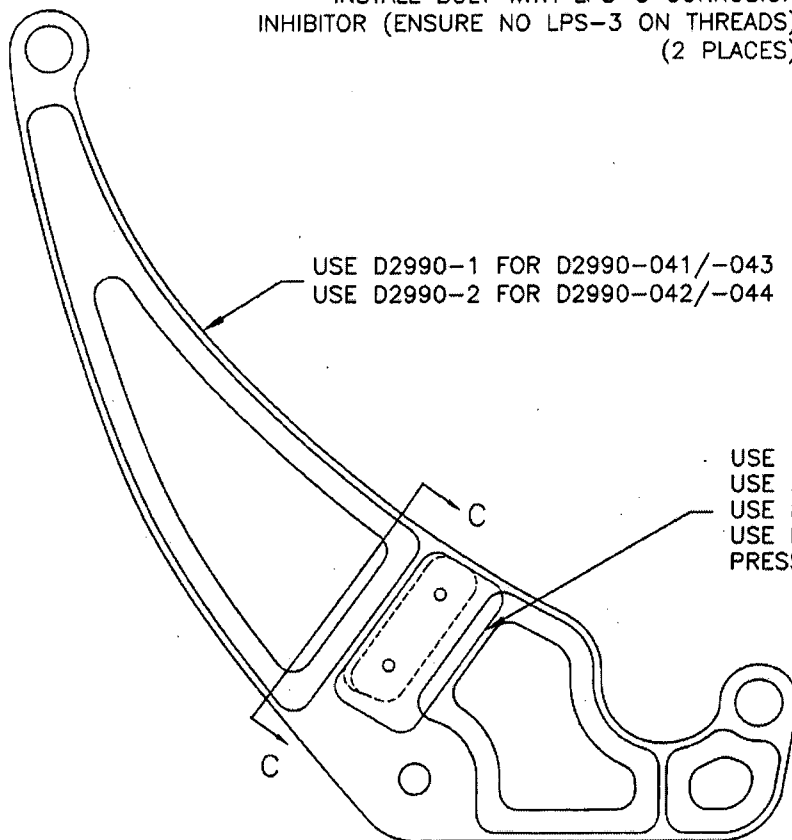
AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



USE D2990-1 FOR D2990-041/-043
USE D2990-2 FOR D2990-042/-044

SECTION C-C
SCALE 1:3
(ROTATED)

USE D2805-1 FOR D2990-041
USE D2805-2 FOR D2990-042
USE D2805-3 FOR D2990-043
USE D2805-4 FOR D2990-044
PRESS INTO PLACE PRIOR TO POWDER COAT



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D2990-041/-043 BRACKET ASS'Y (SHOWN)
D2990-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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